Work Order ID 66057

Thursday, February 03, 2011 11:40:28 AM

ASAP.

Item ID: D4316-041
Revision ID: PRELIM
Item Name: Tube Assembly

Start Date: 2/4/2011 **Start Qty:** 4.00
Required Date: 2/11/2011 **Req'd Qty:** 4.00
Reference:

POSITIVE RECALL

Cust Item ID:
Customer:

PRELIMINARY ISSUE

Accept **Setup Start** **Stop** **Run Start** **Stop**

Approvals: **Process Plan:** MK **Date:** 11-02-03 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D4316	PA1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Large Fab Large Fab	**Memo** 1- Cut D4316-3 as per dwg D4316 2- Drill holes and chamfer holes as per dwg D4316 3- Remove identification marks and deburr	0.00 0.00							
110 QC Quality Control	QC6- Inspect dimensions to drawing **Memo**	0.00 0.00							
120 Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: 111585 **Memo** Grind weld flush as per dwg D4316	0.00 0.00							

1 per Email from 7/02/11 LL

CPC 11.02.10

8/11/02/10

CPC 11.02.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00 8/11/02/10				XY			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00 - Inspection PA/ Dr only 8/11/02/10				XY			
	Memo	0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: B/L	0.00				11.02.15			
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

MF 11-02-15

66051

POSITIVE RECALL
EFFECTIVE 110203 AUTH
RELEASED _____ DATE _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE; Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:40:23 AM

Work Order ID: 66057

Parent Item: D4316-041

Parent Item Name: Tube Assembly

Start Date: 2/4/2011 **Required Date:** 2/11/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP rev:A 11.02.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			120	Each	47.0000	2	8 Cpl 11.02.10			

Location	Loc Qty	Loc Code
WA	47	
54072	9	
65709	38	

M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	104.4944	1.04	4.378947 Cpl 11.02.10			

Location	Loc Qty	Loc Code
MAT	67.54856794	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	25.1993	
116509	19.3317	
116719	14.8672	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	36.9458	
114992	11.0693	
115260	25.8765	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

For Prel. in use only

DART AEROSPACE LTD	Work Order:	66052
Description: tube Assembly	Part Number:	D4316-041
Inspection Dwg: D4316 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

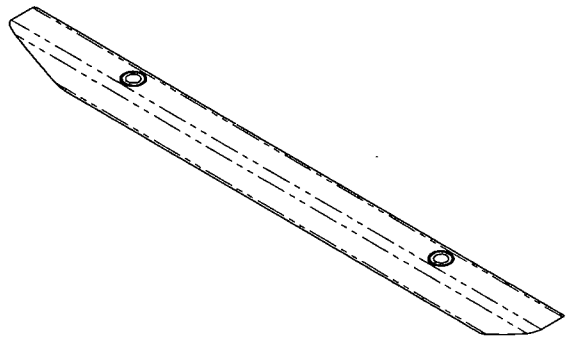
[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.25"	±.030"	7.25"	✓		Vern ED-00926	
			✓			
12.48"	±.030"	12.48	✓		TM-ED-1	
9.59"	±.030"	9.55	✓		"	
0.03" x 45°	±.050 ±½°	.03 x 45°	✓		Vern ED-00926	
ϕ.0.375"	+.006" -.001"	.375"	✓		ED-00926	

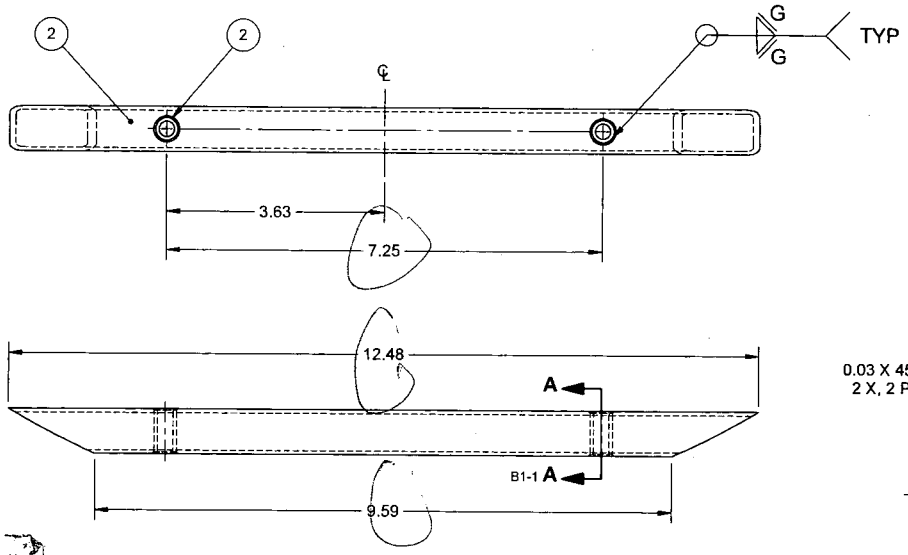
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11.02.10	Date:	11/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

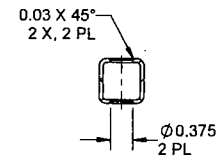
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4316-041	TUBE ASSEMBLY
2	2	D3759	BUSHING
2	1	D4316-3	SUPPORTING RIB



#66057



D4316-041 TUBE ASSEMBLY



SECTION A-A B3-1

PRELIMINARY A1
11.02.01 (AJS)

m304ts0.750w.049
m116719

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4316-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.55 lbs

REV.	DESCRIPTION	BY	DATE
PA1	NEW ISSUE	AJS	11.02.01

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4316	REV. PA1
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE TUBE ASSEMBLY	SCALE NTS
DE APPR.			
DATE	11.02.01		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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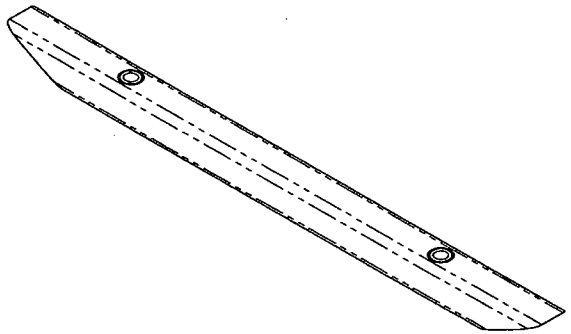
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

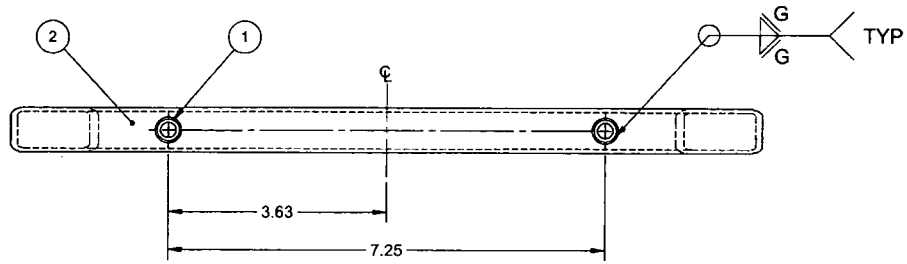
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

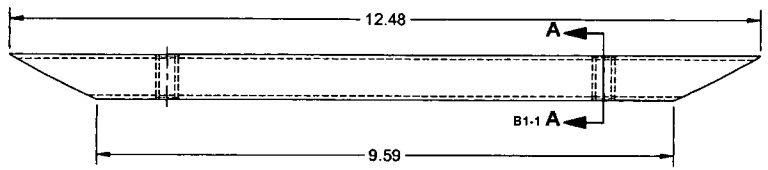
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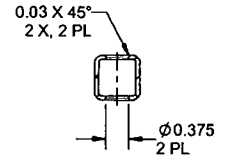
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4316-041	TUBE ASSEMBLY
1	2	D3759-1	BUSHING
2	1	D4316-1	SUPPORTING RIB







D4316-041 TUBE ASSEMBLY



SECTION A-A B3-1

RELEASED
2011 -03- 02

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REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	11.02.03

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4316	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		TUBE ASSEMBLY	NTS
DATE	11.02.03		

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Dart Aerospace Ltd

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